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IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

Applicant: Bernd Schulze  
Serial No: Art Unit:  
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Title: INTERNAL HIGH PRESSURE TRANSFORMING PROCESS  
FOR PRODUCTION OF IN PARTICULAR BELLY SHAPED  
REAR CUT HOLLOW BODIES AND ASSOCIATED DEVICE

Examiner:

February 22, 2000 RUM213R1  
TRANSMITTAL LETTER

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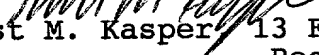
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**APPLICATION FOR UNITED STATES PATENT**

**Inventor(s):** Bernd Schulze

**Invention:** INTERNAL HIGH-PRESSURE DEFORMATION  
METHOD FOR PRODUCTION OF IN  
PARTICULAR BULGING AND UNDERCUT  
HOLLOW BODIES

**Attorney Docket Number:** RUM213

Horst M. Kasper, his attorney  
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Docket No.: RUM213

RUM213SP

# INTERNAL HIGH-PRESSURE DEFORMATION METHOD FOR PRODUCTION OF IN PARTICULAR BULGING AND UNDERCUT HOLLOW BODIES

## BACKGROUND OF THE INVENTION

### 1. Field of the Invention

The Invention relates to an internal high-pressure deformation method for producing in particular bulging and undercut hollow bodies and an associated device and is preferably employed for the production of hollow bodies, where the hollow bodies require a large cross-sectional change during the internal high-pressure deformation.

### 2. Brief Description of the Background of the Invention Including Prior Art

It is known according to the patent document publication WO 98/45692 to employ correspondingly preformed starting parts for a production of tubular hollow bodies with a flange, wherein the attached and welded flange region serves for tensioning in the deformation tool. In case two starting parts are employed, then the two starting parts cannot be again separated from each other and further processed based

on the welding connection in the flange region. The variety of parts produceable is limited to tubular bodies.

Cup shaped preformed starting parts are employed in an internal high-pressure deformation method according to the printed patent document WO 97/29869. The parts are bulged out according to the tool engraving over certain regions by the internal high-pressure deformation method.

The German printed patent document DE 19719426 A1 and the German printed patent document DE 19651658 A1 teach a method for the production of hollow bodies or, respectively, molded parts, wherein tool piece parts are pressure medium sealingly pressed in the region of the flange and are jointly deformed by internal high-pressure deformation, wherein the deforming is performed against two partial engravings, and wherein the partial engravings release the workpiece after the deformation. However bulged hollow bodies are not produceable with this method just as with the device according to German printed patent document DE 19732413 A1, which is subdivided in the planes disposed parallel to each other.

## SUMMARY OF THE INVENTION

### 1. Purposes of the Invention

It is an object of the Invention to develop a method and a device for internal high-pressure deformation, which allows to produce a large variety of parts, in particular of bellied workpieces, wherein it is also possible to process workpiece parts generated together by internal high-pressure deformation separately or jointly after the internal high-pressure deformation and to be able to join the separately further processed tool piece parts again to a hollow body with a precise relative spatial position.

These and other objects and advantages of the present invention will become evident from the description which follows.

### 2. Brief Description of the Invention

The present invention provides that at least two workpiece parts are employed in connection with an internal high-pressure deformation method for the production of a bulging, preferably closed hollow body, wherein at least one

of the two workpiece parts can be preformed like a cup and can exhibit a flange for sealing purposes. The workpiece parts are pressed pressure agent sealingly in the region of the flange in the deformation tool, are jointly formed by the internal high-pressure deforming method and after the internal high-pressure deformation method are separately or jointly further processed, wherein the deformation is performed against an engraving, wherein the parts of the engraving can be moved apart from each other in intersecting axial directions after the deformation. Also more than two workpiece parts can be inserted on top of each other into a deformation tool, and can be tensioned pressure agent sealingly together in the flange region and can be deformed.

A relative motion of the workpiece parts is allowed during the pressure agent sealingly pressing together of the workpiece parts in the flange region, in order to allow an afterflow of the material from the flange region.

A stamping can be performed for the mutual sealing and/or for positional fixing and/or for influencing the flow of the material in the region of the flange simultaneously with the pressure agent sealingly pressing together of the workpiece parts.

The internal high-pressure deformation method can

comprise furnishing a first work piece part with a first flange having a first sealing face, furnishing a second work piece part with a second flange having a second sealing face, wherein the first sealing face is matching the second sealing face to deliver a sealing connection between the first flange and the second flange, disposing the first workpiece part and the second workpiece part such that the first sealing face is disposed opposite to the second sealing face, surrounding the first workpiece and the second workpiece by engraving parts forming a mold, pressing the first sealing face against the second sealing face such that the connection between the first flange and the second flange is sealing for a fluid pressure agent;

feeding pressure agent into a volume delimited by the first workpiece and by the second workpiece, deforming the first workpiece and the second workpiece jointly by internal high-pressure deformation against the engraving parts and effected by the pressure agent;

moving the parts of the engraving away from each other to allow removal of the deformed first workpiece and of the deformed second workpiece from the mold for production of a bulging out and undercut hollow body.

A third workpiece part adjoining the first flange



region can be inserted into the deformation tool. The first flange can be pressed against the third flange in a pressure agent sealing way. The third work piece part together with the first work piece part and the second work piece part can be deformed. A relative motion toward each other of the first work piece part and of the second work piece part can be allowed during the pressure agent sealingly pressing in the region of the first flange and of the second flange. A stamping can be performed in the region of the first flange and of the second flange during the pressure agent sealingly pressing together of the workpiece parts for influencing a flow of the material and/or for supporting a sealing and/or for accomplishing a positional fixation between the individual workpiece parts.

A first engraving part pressing against the first flange can be moved against a second engraving part pressing against the second flange such as to generate a sealing between the first flange and the second flange. Pressure agent can be fed through a docking connection between a pressure feed and an opening in the second workpiece part.

The device for performing the internal high-pressure deformation method is subdivided according to the workpiece

form to be generated and the number of the workpiece parts in different tool planes and exhibits in a closed state an enclosed engraving according to the tool piece form to be generated. Furthermore a docking system for feeding pressure agent for generating the internal high-pressure is furnished. One or several tool planes can be subdivided in different segments according to the workpiece form, wherein the different segments are movable away from the workpiece for removal from the mold in order to assure the production of bulged and undercut workpieces.

The device includes furthermore stamping elements, which generate for example stampings in the region of the flanges of the workpiece parts, wherein the stampings serve to provide a mutual fixation in position and/or a sealing of the workpiece parts.

The tool planes for inserting the workpiece and the tool planes for removing the workpiece can be coinciding or different.

The invention furnishes for the first time a solution, where very bulging and undercut hollow bodies can be produced with

internal high-pressure deformation and which method assures that several workpiece parts can be produced at the same time, wherein the work piece parts can be further processed either separately or jointly. A positional fixing is advantageous in case of a separate processing of the work piece parts and these thereupon following joining of the work piece parts to form a hollow body.

The novel features which are considered as characteristic for the invention are set forth in the appended claims. The invention itself, however, both as to its construction and its method of operation, together with additional objects and advantages thereof, will be best understood from the following description of specific embodiments when read in connection with the accompanying drawing.

#### BRIEF DESCRIPTION OF THE DRAWING

In the accompanying drawing, in which are shown several of the various possible embodiments of the present invention:

Fig. 1 is a sectional view of an internal high-pressure deformation device for a simultaneous internal

high-pressure forming of a first work piece part and of a second work piece part starting position prior to pressing,

Fig. 2: is a sectional view of the internal high-pressure deformation device according to Fig. 1 according to the internal high-pressure deforming method after pressing,

Fig. 3: is a sectional view of the opened internal high-pressure deformation device according to Fig. 1 allowing removal of the deformed workpiece,

Fig. 4: is a sectional view of the embodiment of Fig. 3 along section lines 4 - 4 according to Fig. 3,

Fig. 5: is a sectional view of detail "B" according to Fig. 2,

Fig. 6: is a sectional view of a second embodiment of an internal high-pressure deformation tool for the simultaneous deforming of two starting parts furnished in the form of cups.

#### DESCRIPTION OF INVENTION AND PREFERRED EMBODIMENT

A deep drawn cup is employed as a workpiece part 1 and a planar sheet metal round blank is employed according to Fig. 1. The topological geometry corresponds to that of a pot having a cover. The device comprises three tool regions disposed in different planes, the upper region E1,

the middle region E2, and the lower region E3. The upper region E1 is associated with the cover and the middle region E2 and the lower region E3 are associated with the pot part.

The top bank is furnished with a first flange and the cup is furnished with a second flange. The first flange and the second flange are laid out for superposition such that the cup and the cover blank are closed when the first flange and the second flange are pressed together. The width of the first flange is preferably equal to from about 0.8 to 1.2 times the width of the second flange. The width of the second flange can be from about 0.01 to 0.1 times the outer diameter of the cup and is preferably from about 0.02 to 0.05 of the diameter of the cup. The second flange is preferably flat and disposed in a plane, however other geometries of the second flange can be provided under the condition that the adjoining sealing surface of first flange matches the sealing surface of the second flange and the mold parts are correspondingly formed. For example, the flanges can be circular flanges and the sealing surfaces of the flanges can be conical surfaces, where the cone angles of the two flanges are substantially equal.

The first subdivision plane T1 between the first region E1 and to the second region E2 is disposed between

the flanges 1.1 and 2.1 of the work piece parts 1 and 2. Preferably a first region presses against the first flange and a second region presses against a second flange such as to generate a seal between the flanges. A tensioning means is furnished which presses the first region E1 against the second region E2 in the area of the first flange and of the second flange. An engraving 3 is disposed in the upper region E1, an engraving 4 is disposed in the middle region E2, and an engraving 5 is disposed in the lower region E3, wherein the engravings together correspond to the form of the workpiece to be produced. The engravings together form an outer mold for the deforming of the cup and the cover blank. The engraving 3 forms here a mold for the sheet metal round blank (work piece part 2), the engravings 4 and 5 form the bulged out mold for the cup (starting part 1). The second subdivision plane T2 is disposed between the regions E2 and E3 in the outermost point of the engravings 4 and 5.

An additional forming element F (Figs. 1,2,3) is disposed in the engraving 5. The additional forming element F can be described as a concave section in the overall convex surface of the cup. A pressure agent feed 6 in the kind of a docking system is furnished in the region E3.

Preferably a sealed connection is provided between the pressure agent feed and an opening in the wall of the cup 1. Two work piece parts 1,2 were inserted into the device according to Fig. 1 and the three regions E1, E2, E3 are closed. All regions E1, E2, E3, are tensioned relative to each other by a tensioning means and the flanges 1.1 and 2.1 are pressed together pressure agent sealingly. The two work piece parts are not connected to each other for example by welding or beading, but are only pressed to each other pressure agent sealingly based on the closure force of the close setting of the flanges.

The pressure agent D is fed through the pressure agent feed 6 and is subjected to high-pressure. The walls of the two work pieces 1 and 2 are thereby bulged out and laid at the engravings 3,4 and 5 according to Fig. 2 and thus also at the additional forming element F.

Preferably a hole is provided in the blank and the position of the hole is matched with a position of an end of the pressure agent feed such that the pressure agent ends up inside of the blank to be deformed. The connection between the pressure agent feed and the work piece part 2 can be of a docking connection type. The deformation distance can be from about 0.01 to 0.2 times the maximum diameter of the

first work piece part and is preferably from about 0.02 to 0.05 times the maximum diameter of the first workpiece part.

The device is opened after the internal high-pressure deformation. For this purpose the upper region E1 moves in the direction to the axis A of the work piece parts 1,2 vertically in upward direction according to Figs. 3 and 4. The middle region E3 comprises four segments S1, S2, S3, S4, which are in this case opened horizontally (at a right angle relative to the axis A of the work piece parts 1,2 toward the outside, that is away from the work piece parts 1,2). The outward motion of the regions and segments is constructed such that they release the deformed workpiece without interference. The removal of the regions and segments can be performed simultaneously or successively. The internal high-pressure deformed hollow body W can be removed from the device now, wherein the internal high-pressure deformed hollow body W is composed of the two work piece parts 1 and 2. The two work piece parts 1, 2 can now be further processed either separately or jointly.

In order to achieve a precise positional location and in order to achieve a good sealing between the two work piece parts 1,2 (work piece parts W1, W2), a form element F2 can be furnished in the flanges 1.1 and 2.1 for example by



stamping (compare figure 5). The form element 2 can have preferably a rectangular or a circular segment shape. A recess 7 and a thereto corresponding stamping projection 8 are furnished for this purpose in the regions E1 and E2 directed in the direction of the flanges 1.1 and 2.1.

The two work piece parts 1 and 2 can be processed separately from each other after the internal high-pressure deformation and can in the following again be joined to form the hollow body W, wherein a precise positional location and the determination is assured between the two work piece parts 1 and 2 by the stamping. The flange cannot be employed for the sealing of other component parts, which usually is not possible in parts formed by internal high-pressure deformation based on a lack of a flange.

Based on the kind of the subdivision of the tool, it is for the first-time possible to produce such bulging out and undercut hollow bodies. The two work piece parts 1,2 can be joined to form a closed hollow body (work piece W) for example by welding of the flanges 1.1, 2.1 with or without further processing, wherein the closed hollow body in this shape has not been produceable in the past by internal high-pressure deforming.

The two starting parts can also be connected to each

other permanently and non-disengageably by beading in the flange region according to a further embodiment not illustrated. There exists furthermore the possibility to manufacture a work piece with several bulged out regions, wherein the number of the regions and the subdivision planes and the number of the segments of the regions of the device have to be newly fixed.

A possible variation of an embodiment according to the internal high-pressure deformation methods is illustrated in Fig. 6. Two work piece parts 1 and 2 in the form of deep drawn cups (illustrated in dashed lines in the starting position) are employed for this purpose. The two work piece parts 1 and 2 are resting with their flanges 1.1, 2.1 at each other and are pressed to each other pressure agent sealingly in the region. The pressure agent feed is performed through a docking system 6, which leads through between the two flanges 1.1, 2.1. The tool is subdivided in a total of four regions. The region E1 is disposed in the upper most position in the presentation according to Fig. 6. Then follows the region E2, where the flange 2.1 of the second cup (second tool piece 2) rests at the region E2. Following thereto the region E3 is disposed, wherein the region E3 receives the flange 1.1 of the first work piece

part 1 (cup). The region E4 is disposed below the third region E3. Overall the regions E1 and E2 exhibit an engraving 4, which determines the final form of the workpiece parts 1 and 2. The subdivision plane T1 is disposed between the regions E1 and E2 and the subdivision plane T3 is disposed between the region E3 and E4 in each case in the region of the engravings 3,4 with the largest outer diameter in order to assure a removal of the workpiece from the mold. The subdivision plane T2 is disposed between the region E2 and E3, wherein the flanges 1.1 and 2.1 of the workpiece parts are also received and pressed in the subdivision plane T2. The subdivision planes T1 through T3 are disposed perpendicular to the axis A of the workpieces 1 and 2. The individual regions E1 through E4 can be subdivided additionally in several segments S. The two flanges 1.1 and 2.1 are also pressed pressure agent sealingly and the two work piece parts 1,2 are deformed by pressure impact with the pressure agent D.

The region E1 moves in arrow direction parallel to the axis A of the workpiece parts vertical upwardly and the segments S of the regions E1 through E4 also move according to the arrow direction as a right angle relative to the axis A of the workpiece parts (horizontal) away from the tool

piece for removing the formed part from the mold. After the complete opening of the device, the hollow body W can be taken out of the device.

It is also possible that the segments S, S1 through S4 according to the form of the workpiece are not disposed at a right angle relative to the axis A of the workpiece parts 1,2, but are removable at a different angle away from the workpiece in addition to the embodiments illustrated here.

It will be understood that each of the elements described above, or two or more together, may also find a useful application in other types of forming configurations and molding procedures differing from the types described above.

While the invention has been illustrated and described as embodied in the context of an internal high-pressure deformation method for a production of bulging out and undercut hollow bodies, it is not intended to be limited to the details shown, since various modifications and structural changes may be made without departing in any way from the spirit of the present

invention.

Without further analysis, the foregoing will so fully reveal the gist of the present invention that others can, by applying current knowledge, readily adapt it for various applications without omitting features that, from the standpoint of prior art, fairly constitute essential characteristics of the generic or specific aspects of this invention.

What is claimed as new and desired to be protected by Letters Patent is set forth in the appended claims.

1. An internal high-pressure deformation method comprising furnishing a first work piece part with a first flange having a first sealing face;  
furnishing a second work piece part with a second flange having a second sealing face, wherein the first sealing face is matching the second sealing face to deliver a sealing connection between the first flange and the second flange;  
disposing the first workpiece part and the second workpiece part such that the first sealing face is disposed opposite to the second sealing face;  
surrounding the first workpiece and the second workpiece by

engraving parts forming a mold;  
pressing the first sealing face against the second sealing face such that the connection between the first flange and the second flange is sealing for a fluid pressure agent;  
feeding pressure agent into a volume delimited by the first workpiece and by the second workpiece;  
deforming the first workpiece and the second workpiece jointly by internal high-pressure deformation against the engraving parts and effected by the pressure agent;  
moving the parts of the engraving away from each other to allow removal of the deformed first workpiece and of the deformed second workpiece from the mold for production of a bulging out and undercut hollow body.

2. The internal high-pressure deformation method according to claim 1 further comprising  
inserting a third workpiece part adjoining the first flange region into the deformation tool; and  
pressing the first flange against the third flange in pressure agent sealing way;  
deforming the third work piece part together with the first work piece part and the second work piece part.

3. The internal high-pressure deformation method according to claim 1 further comprising allowing a relative motion toward each other of the first work piece part and of the second work piece part during the pressure agent sealingly pressing in the region of the first flange and of the second flange.

4. The internal high-pressure deformation method according to claim 1 further comprising performing a stamping in the region of the first flange and of the second flange during the pressure agent sealingly pressing together of the workpiece parts for influencing a flow of the material and/or for supporting a sealing and/or for accomplishing a positional fixation between the individual workpiece parts.

5. The internal high-pressure deformation method according to claim 1 further comprising moving a first engraving part pressing against the first flange against a second engraving part pressing against the second flange such as to generate a sealing between the first flange and the second flange.

6. The internal high-pressure deformation method according to claim 1 further comprising feeding pressure agent through a docking connection between a pressure feed and an opening in the second workpiece part.

7. An apparatus for production of bulged out and undercut hollow bodies comprising

a first tool region;

a second tool region;

a third tool region, wherein the first tool region, the second tool region and the third tool region correspond to the workpiece form to be generated and to a first workpiece part and to a second workpiece part, wherein the tool regions are disposed in different planes, and wherein at least one of the tool regions is subdivided into two segments according to the shape of a corresponding one of the workpiece parts;

first means for flange pressing disposed at the first tool region;

second means for flange pressing disposed at the second tool region, wherein the first means for flange pressing and the second means for flange pressing are adapted to press a first flange of the first workpiece part and a second flange



of the second workpiece part sealingly together;  
means for moving the tool regions and the segments away from  
a hollow body formed of the first workpiece part and of the  
second workpiece part for a removal of the hollow body from  
the mold.

8. The apparatus according to claim 7 further comprising  
stamping means disposed in the region of the first flange  
and of the second flange.

9. The apparatus according to claim 7 wherein the tool  
regions for insertion of the workpiece coincide with the  
tool planes for removal of the hollow body.

10. The apparatus according to claim 7 wherein the tool  
regions for insertion of the workpiece do not coincide with  
the tool planes for removal of the hollow body.

11. An internal high-pressure deformation method for the  
production of in particular bulging out and undercut hollow  
bodies by employing at least two workpiece parts (1,2),  
which two workpiece parts (1,2) are pressed pressure agent  
sealingly in the region of a flange (1. 1,1.2) and which

two workpiece parts (1,2) are deformed jointly by the internal high-pressure deformation, wherein the deforming is performed against an engraving, wherein the parts of the engraving are movable away from each other in a direction of intersecting axes.

12. The internal high-pressure deformation method according to claim 11 wherein more than two workpiece parts (1,2) adjoining each other in the flange region are inserted into the deformation tool and are pressed against each other pressure agent sealingly in the flange region and are deformed.

13. The internal high-pressure deformation method according to claim 11 wherein the work piece parts (1,2) allow a relative motion toward each other during the pressure agent sealingly pressing in the flange region (1.1, 2.1).

14. The internal high-pressure deformation method according to claim 11 wherein a stamping is performed in the region of the flanges (1.1, 2.1) during the pressure agent sealingly pressing together of the work tool pieces (1,2) in order to influence the flow of the material and/or to support the

sealing and/or to accomplish a positional fixation between the individual workpiece parts (1,2).

15. An apparatus for production of in particular bulged out and undercut hollow bodies, wherein the apparatus is subdivided in tool regions (E1, E2, E3, E4) corresponding to the workpiece form to be generated and the number of workpiece parts (1, 2), wherein the tool regions (E1, E2, E3, E4) are disposed in different planes, wherein one or several tool regions (E1, E2, E3, E4) are subdivided in different segments (S, S1, S2, S3, S4) according to the shape of the workpiece, wherein the segments (S, S1, S2, S3, S4) are movable away from the hollow body (W) for removal of the hollow body (W) from the mold.

16. The apparatus according to claim 15 further comprising stamping elements disposed in the region of the flanges (1.1, 2.1).

17. The apparatus according to claim 15 wherein the tool regions (E1, E2, E3, E4) for insertion of the workpiece coincide or do not coincide with the tool planes for removal of the work piece.

## ABSTRACT OF THE DISCLOSURE

An internal high-pressure deformation method for the production of in particular bulging out closed hollow bodies and a corresponding device are disclosed. At least two workpiece parts (1,2) are employed, wherein at least one of the two workpiece parts (1,2) preformed of cup shape and exhibits a flange, and are pressure agent sealingly pressed in the region of the flanges (1. 1,1.2) in the deformation tool according to the invention such that the two work tool pieces (1,2) are together deformed by the internal high-pressure deformation method and are further processed separately or jointly after the internal high-pressure deformation. The apparatus is subdivided in tool regions (E1, E2, E3, E4) corresponding to the work piece forms to be generated and corresponding to the number of the workpiece parts (1,2), wherein the tool regions (E1, E2, E3, E4) are disposed in different planes (figure 2).

An internal high-pressure deformation method for the production of in particular bulging out closed hollow bodies and a corresponding device are disclosed. At least two workpiece parts (1,2) are employed, wherein at least one of the two workpiece parts (1,2) preformed of cup shape and exhibits a flange, and are pressure agent sealingly pressed in the region of the flanges (1. 1,1.2) in the deformation tool according to the invention such that the two work tool pieces (1,2) are together deformed by the internal high-pressure deformation method and are further processed separately or jointly after the internal high-pressure deformation. The apparatus is subdivided in tool regions (E1, E2, E3, E4) corresponding to the work piece forms to be generated and corresponding to the number of the workpiece parts (1,2), wherein the tool regions (E1, E2, E3, E4) are disposed in different planes (figure 2).

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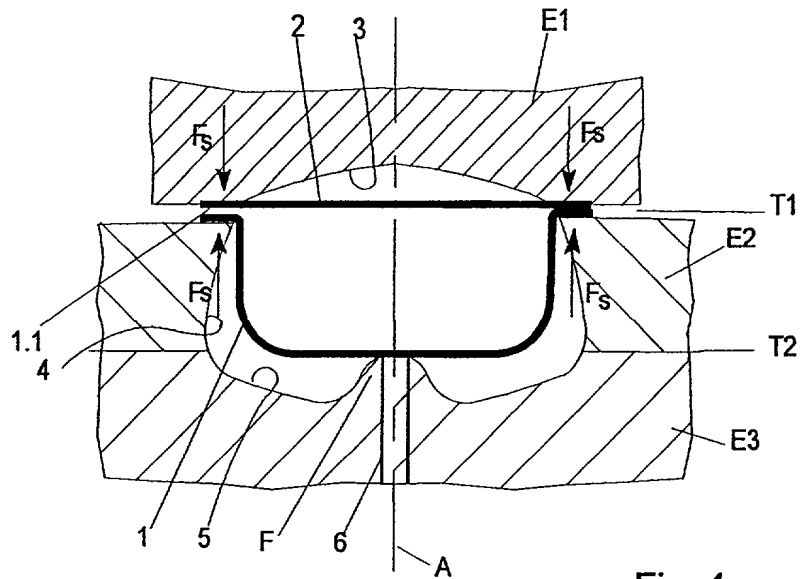


Fig. 1

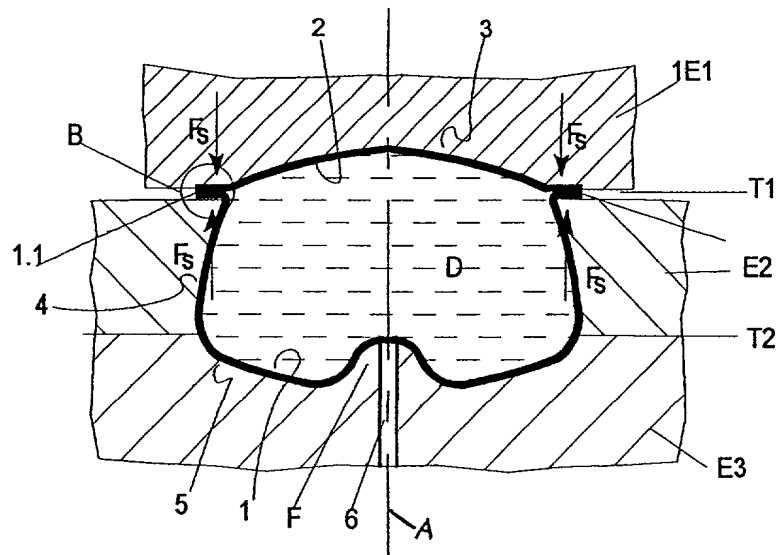
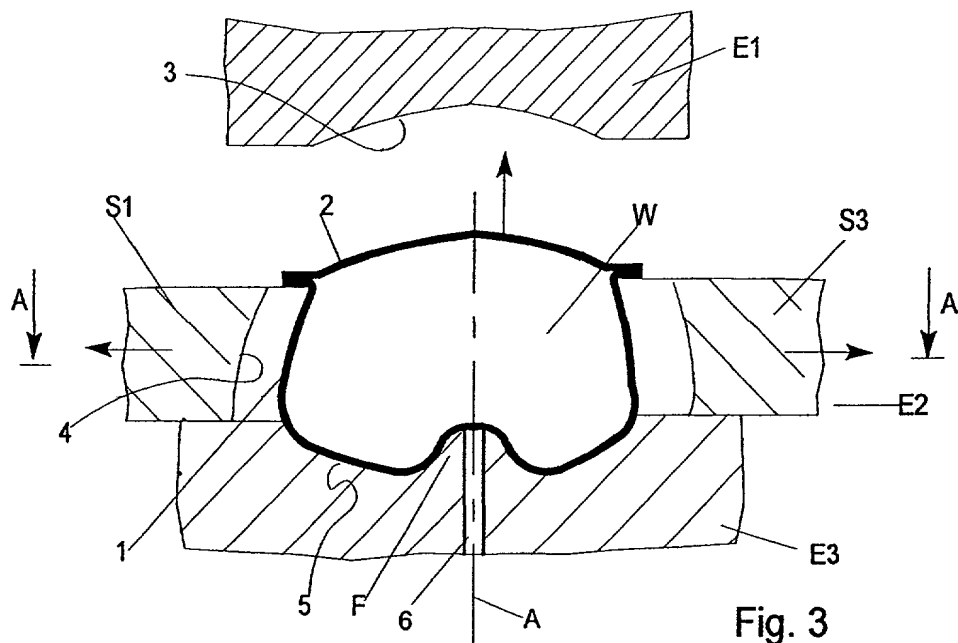
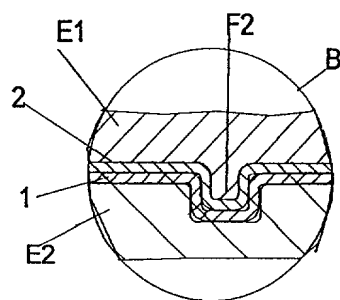
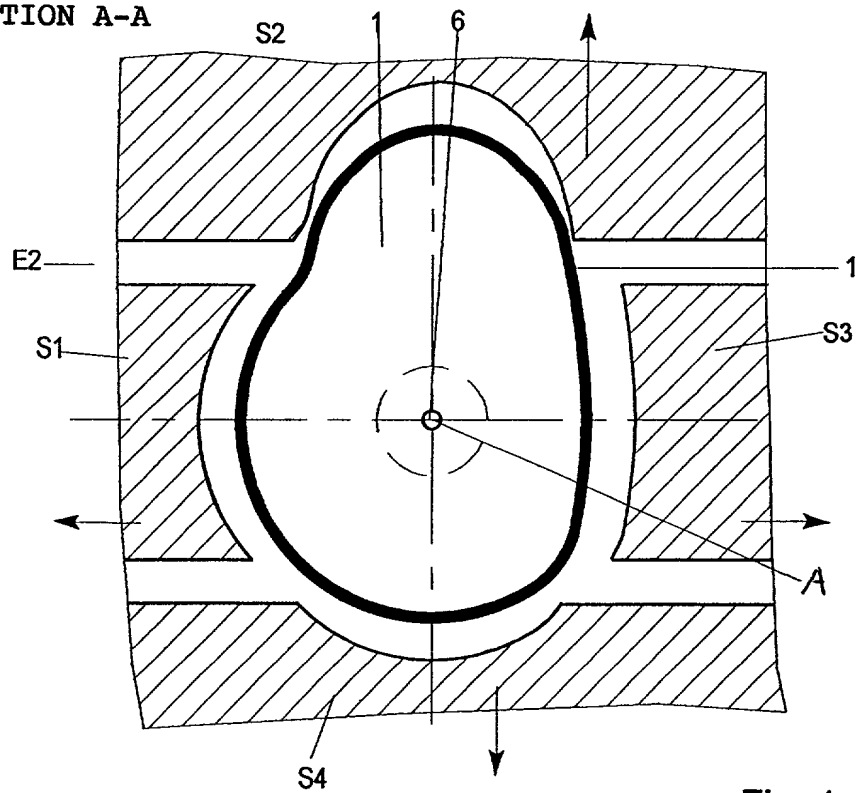


Fig. 2



CROSS SECTION A-A



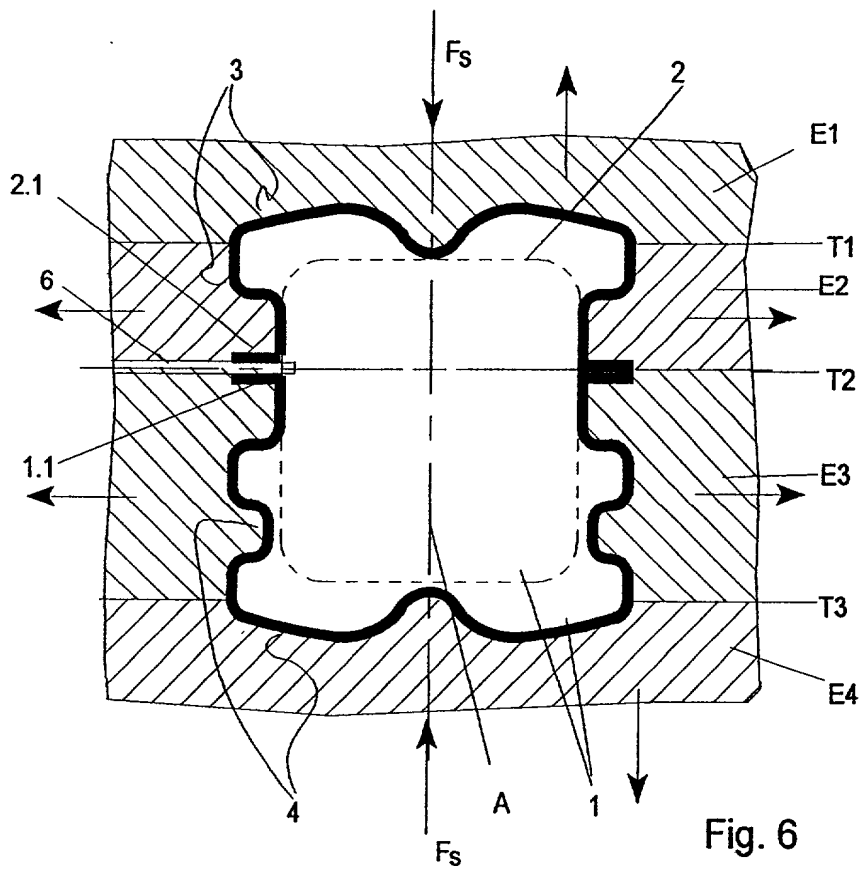


Fig. 6



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Applicant: Bernd Schulze

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Filing Date:

Title: INTERNAL HIGH PRESSURE TRANSFORMING PROCESS FOR  
PRODUCTION OF IN PARTICULAR BELLY SHAPED REAR CUT  
HOLLOW BODIES AND ASSOCIATED DEVICE**DECLARATION AND POWER OF ATTORNEY FOR PATENT APPLICATION**  
**Erklärung Für Patentanmeldungen Mit Vollmacht**  
German Language Declaration Rum213Als nachstehend benannter Erfinder erkläre ich hiermit an  
Eidesstatt:

As a below named inventor, I hereby declare that:

daß mein Wohnsitz, meine Postanschrift und meine Staats-  
angehörigkeit den im Nachstehenden nach meinem Namen aufgeführten  
Angaben entsprechen,My residence, post office address and citizenship are as stated  
below next to my name,daß ich, nach bestem Wissen der ursprüngliche, erste und  
alleinige Erfinder (falls nachstehend nur ein Name angegeben ist)  
oder ein ursprünglicher, erster und Miterfinder (falls  
nachstehend mehrere Namen aufgeführt sind) des Gegenstandes bin,  
für den dieser Antrag gestellt wird und für den ein Patent  
beantragt wird für die Erfindung mit dem Titel:**Innenhochdruckumformverfahren zur Herstellung insbesondere  
bauchiger hinterschnittener Hohlkörper und zugehörige Vorrichtung**I believe I am the original, first and sole inventor (if only one  
name is listed below) or an original, first and joint inventor  
(if plural names are listed below) of the subject matter which is  
claimed and for which a patent is sought on the invention  
entitled:**INTERNAL HIGH PRESSURE TRANSFORMING PROCESS FOR  
PRODUCTION OF IN PARTICULAR BELLY SHAPED REAR CUT HOLLOW  
BODIES AND ASSOCIATED DEVICE**

Inventor Declaration of Bernd Schulze

Page 1 of 5

deren Beschreibung (nur eines der nachfolgenden Kästchen ankreuzen)

the specification of which (check only one item below)

< > hier beigelegt ist  
is attached hereto.

< > am ..... als U.S.-Anmeldung, Seriennummer  
eingereicht wurde und am ..... abgeändert wurde  
(falls tatsächlich abgeändert).

was filed as US Application Serial No.....  
on ..... and was amended on.....(if applicable).

< > am ..... als internationale PCT-Anmeldung, Nummer  
eingereicht wurde und am ..... unter PCT-Artikel 19  
abgeändert wurde (falls tatsächlich abgeändert).

was filed as PCT international application, Number.....  
on ..... and was amended under PCT Article 19  
on ..... (if applicable)

Ich bestätige hiermit, daß ich den Inhalt der obigen  
Patentanmeldung einschließlich der Ansprüche durchgesehen und  
verstanden habe, die eventuell durch einen Zusatzantrag wie oben  
erwähnt abgeändert wurde.

I hereby state that I have reviewed and understand the contents  
of the above-identified specification, including the claims, as  
amended by any amendment referred to above.

Ich erkenne meine Pflicht zur Offenbarung jeglicher Informationen  
an, die zur Prüfung der Patentfähigkeit in Einklang mit Titel 37,  
Bundesgesetzbuch (Code of Federal Regulation), § 1.56 von Belang  
sind.

I acknowledge the duty to disclose information which is material  
to patentability as defined in Title 37, Code of Federal  
Regulations, § 1.56.

Ich beanspruche hiermit ausländische Prioritätsvorteile gemäß  
Abschnitt 35 der Zivilprozeßordnung der Vereinigten Staaten,  
Paragraph 119 jeglicher unten angegebenen Auslandsanmeldung(en)  
für ein Patent oder Erfindersurkunde oder jeglicher  
internationalen PCT-Anmeldung(en), welche mindestens ein Land  
ausser den Vereinigten Staaten benennt, und habe auch jegliche  
Auslandsanmeldung(en) für ein Patent oder Erfindersurkunde oder  
jegliche internationale PCT-Anmeldung(en), welche mindestens ein

Land ausser den Vereinigten Staaten benennt, nachstehend gekennzeichnet, welche von mir für den gleichen Gegenstand eingereicht wurde und ein Anmeldedatum haben, das vor dem Anmeldedatum der Anmeldung liegt, für die Priorität beansprucht wird.

I hereby claim foreign priority benefits under Title 35, United States Code, §119 of any foreign application(s) for patent or inventor's certificate or of any PCT international application(s) designating at least one country other than the United States of America listed below and have also identified below any foreign application(s) for patent or inventor's certificate or any PCT international application(s) designating at least one country other than the United States of America filed by me on the same subject matter having a filing date before that of the application(s) of which priority is claimed:

**PRIOR FOREIGN /PCT APPLICATION(S) AND ANY PRIORITY CLAIMS UNDER 35 USC 119:**

**FRÜHERE AUSLÄNDISCHE/PCT ANMELDUNG(EN) UND JEGLICHE PRIORITÄT UNTER 35 USC 119:**

Country (if PCT, indicate PCT) Land (falls PCT, PCT angeben)	Application No. Anmeldungsnummer	Date of Filing (day, month, year) Anmeldedatum (Tag, Monat, Jahr)	Priority Claimed under 35 USC 119 Priorität unter 35 USC 119 beansprucht
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Germany	199 07 247.7	19 February 1999	<input checked="" type="checkbox"/> Yes <input type="checkbox"/> No Ja Nein
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Ich beanspruche hiermit gemäß Absatz 35 der Zivilprozeßordnung der Vereinigten Staaten, Paragraph 120, den Vorzug jeglicher unten aufgeführten U.S.-Anmeldung(en) oder die USA benennende internationale(n) PCT-Anmeldung(en) und falls der Gegenstand aus jedem Anspruch dieser Anmeldung nicht in dieser/diesen früheren Patentanmeldung(en) laut dem ersten Paragraphen des Absatzes 35 der Zivilprozeßordnung der Vereinigten Staaten, Paragraph 112 offenbart ist, erkenne ich gemäß Absatz 37, Bundesgesetzbuch, Paragraph 1.56(a) meine Pflicht zur Offenbarung von Informationen an, die zwischen dem Anmeldedatum der früheren Anmeldung(en) und dem nationalen oder internationalen PCT Anmeldedatum dieser Anmeldung bekannt geworden sind.

I hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) or PCT international application(s) designating the United States of America that is/are listed below and, insofar as the subject matter of each of

the claims of this application is not disclosed in that/those prior application(s) in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose material information as defined in Title 37, Code of Federal Regulations, §1.56(a) which occurred between the filing date of the prior application(s) and the national or PCT international filing date of this application:

**PRIOR U.S. APPLICATIONS OR PCT INTERNATIONAL APPLICATIONS DESIGNATING THE U.S. FOR BENEFIT UNDER 35 USC 120:**

**FRÜHERE AMERIKANISCHE ANMELDUNGEN ODER DIE USA BENENNENDE INTERNATIONALE PCT-ANMELDUNGEN FÜR VORRECHT UNTER 35 USC 120**

U.S. APPLICATIONS		STATUS (Check one)
U.S. Application No.	U.S. Filing Date	Patented Pending Abandoned
AMERIKANISCHE ANMELDUNGEN		STAND (ein Kästchen ankreuzen)
Seriennummer	Anmeldedatum	Patentiert Anhängig Aufgegeben
		< > < > < >

**PCT APPLICATIONS DESIGNATING THE U.S.**

PCT Application PCT Filing Date U.S.Ser.Nos.  
Number assigned (if any)

**DIE USA BENENNENDE PCT-ANMELDUNGEN**

PCT-Anmelde-	PCT-Anmeldedatum	Zuteilte Serien-
nummer		nummern (falls zutreffend)
		< > < > < >

**VERTRETUNGSVOLLMACHT:** Als benannter Erfinder beauftrage ich hiermit den nachstehend benannten Patentanwalt (oder die nachstehend benannten Patentanwälte) und/oder Patent-Agenten mit der Verfolgung der vorliegenden Patentanmeldung sowie mit der Abwicklung aller damit verbundenen Geschäfte vor dem Patent- und Warenzeichenamt: (Name und Registrationsnummer anführen)

**POWER OF ATTORNEY:** As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith. (List name and registration number)

Horst M. Kasper (Reg. No. 28,559)  
Richard T. Laughlin (Reg. No. 17,264)

Telefongespräche bitte richten an: (Name und Telefonnummer)  
Direct Telephone Calls to: (Name and telephone number)  
Horst M. Kasper (908) 757-2839

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Ich erkläre hiermit, daß alle von mir in der vorliegenden Erklärung gemachten Angaben nach meinem besten Wissen und Gewissen der vollen Wahrheit entsprechen, und daß ich diese eidesstattliche Erklärung in Kenntnis dessen abgebe, daß wissentlich und vorsätzlich falsche Angaben gemäß Paragraph 1001, Absatz 18 der Zivilprozessordnung der Vereinigten Staaten von Amerika mit Geldstrafe belegt und/oder Gefängnis bestraft werden können, und daß derartig wissentlich und vorsätzlich falsche Angaben die Gültigkeit der vorliegenden Patentanmeldung oder eines darauf erteilten Patentes gefährden können.

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

Voller Name des einzigen oder ursprünglichen Erfinders:

Full name of sole or first inventor:

Bernd Schulze

Unterschrift des Erfinders  
Inventor's signature

....Bernd Schulze....

Datum

Date

2.1.02.00

Wohnsitz

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PTO 1391 (10-83)

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